

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013375**Date Inspected:** 03-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Liu Hua Jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 045175 perform Flux Cored Arc Welding (FCAW) Welding on Corner Assembly, weld joint identified as CA3011E-PP117-223, 224, 227 and 228. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133.

This QA inspector observed ZPMC qualified welding personnel identified as 045175 perform Flux Cored Arc Welding (FCAW) Welding on Corner Assembly, weld joint identified as CA3011E-PP116.5-023, 024, 029 and 030. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133. See the attached pictures

This QA inspector observed ZPMC qualified welding personnel identified as 045175 perform Flux Cored Arc Welding (FCAW) Welding on Corner Assembly, weld joint identified as CA3011C-PP115-001~012. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-4133.

This QA inspector observed ZPMC qualified welding personnel identified as 044771 perform Submerged Arc

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Welding (SAW) Welding on Segment 12BE, weld joint identified as SEG3002-008. ZPMC QC is identified as Mr. Guo Xing Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 045265 perform Submerged Arc Welding (SAW) Welding on Segment 12BE, weld joint identified as SEG3006-001. ZPMC QC is identified as Mr. Guo Xing Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 044774 perform FCAW Welding on Traveler Rail, weld joint identified as 10TR3-024. ZPMC QC is identified as Mr. Guo Pan. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-Repair, which is used as per Critical Welding Repair Report (CWR) B-WR1086.

This QA inspector observed ZPMC qualified welding personnel identified as 206623 perform FCAW Welding on Traveler Rail, weld joint identified as 11TR3-011. ZPMC QC is identified as Mr. Guo Pan. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-Repair, which is used as per Critical Welding Repair Report (CWR) B-WR1086.

This QA inspector observed ZPMC qualified welding personnel identified as 208035 perform FCAW Welding on Traveler Rail, weld joint identified as 10TR3-021. ZPMC QC is identified as Mr. Guo Pan. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-Repair, which is used as per Critical Welding Repair Report (CWR) B-WR1086.

This QA inspector observed ZPMC qualified welding personnel identified as 214945 perform FCAW Welding on Traveler Rail, weld joint identified as 11TR1-014. ZPMC QC is identified as Mr. Guo Pan. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-Repair, which is used as per Critical Welding Repair Report (CWR) B-WR1086.

This QA inspector observed ZPMC qualified welding personnel identified as 055564 perform FCAW Welding on Traveler Rail, weld joint identified as 11TR2-014. ZPMC QC is identified as Mr. Guo Pan. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-Repair, which is used as per Critical Welding Repair Report (CWR) B-WR1086.

Outside Yard: Segment 9CW.

This QA inspector observed ZPMC qualified welding personnel performing weld repair / correction on Flange Plate X7K of PP77, PP78, and PP79 to maintain the required radius R50mm. The welding process is identified as Shielded Metal Arc Welding (SMAW) and the welders are identified as 067088 and 037748. ZPMC QC is identified as Mr. Li Yan Hua. The welding variables recorded by QC appeared to comply with the applicable WPS: 345-SMAW-1G (1F)-Repair, which is used as per Welding Repair Report (WRR) B-WR10732.

This QA inspector observed ABF personnel performing Ultrasonic Testing on side plate to bottom joint welds at OBG Segment 9CW. See the attached picture

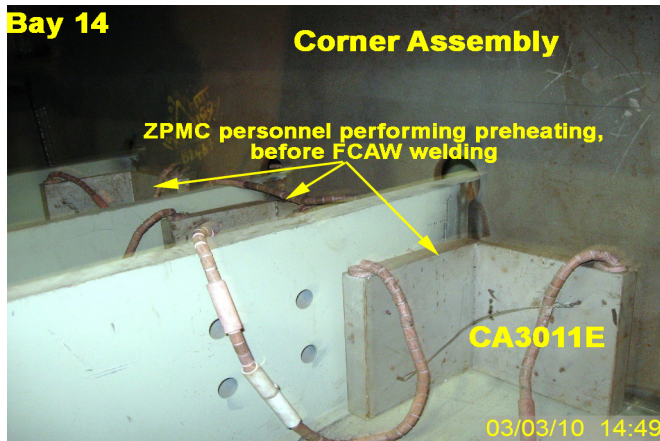
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Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



## Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

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**Inspected By:** Kumar,Vibin

Quality Assurance Inspector

**Reviewed By:** McClendon,Timothy

QA Reviewer

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